

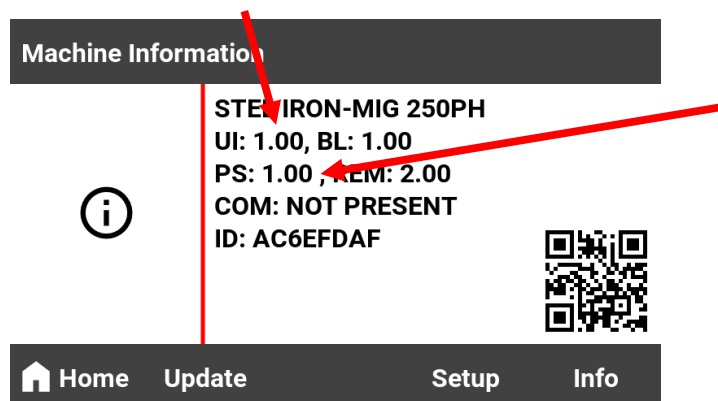
IRON-MIG 235/250 Programming instructions

Note

Please read the update instructions carefully before updating the machine. Failure to follow the update procedure correctly may result in machine damage.

Update procedure

- Get an USB stick, refer to the notes below to choose the correct flash drive;
- Copy the “*.suf” file in the USB stick, in the root, not inside a folder. There must be only one “.suf” file in this place. The USB stick can contain any other types of files/folder and even others .suf file, but they have to be placed inside a folder, not in the main path;
- Ensure the welding power source is connected to a reliable power supply, **it is important that during the update procedure the machine stays ON and connected to the power line!**
- Insert the USB stick on the machine;
- With the machine turned on, navigate to the “Information screen” and press “Update”;
- The machine will start the update process and will shows progress and eventual error messages. **Do not disconnect the USB while leds near the port are on!**
- The update procedure can last few minutes and the machine can seems stuck;
- When the machine reboots, it will show the new software version of the main software (see image below).



Errors

Error code	Description	Solution
152	USB flash drive not found	Check USB connection, try another USB stick, see notes below on USB drive.
128	COM board not found	
154	File not found or too many files found	Check the presence of only one file on the drive
130,131,156,157,158	Incompatible file	Check update file, version and model, try again.
Others	Internal errors	Turn the machine off and on and retry

If error persists, contact factory authorized service agent.

USB Drive specifications

The USB supports FAT and exFAT file systems but is limited to the MBR partition standard. As a result, some "large" USB sticks (e.g., 128GB, 256GB) may not work if they use the GPT partition standard.

Large USB mass storage requiring more than 150mA may not work properly.